



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5489-047
Job Sheet 181190

Accounting Job OV18-11



Part No: D5489-047

Job Qty: 2 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: IPP REV:A 17.11.03 AS PER DWG REV:A DD VERF:JFS

Ship Via:

Make per Rev. A D5489-047

POSITIVE RECALL
EFFECTIVE DATE 24 2018 AUTH 21
RELEASED 5 DATE 18/7/18

* Approved Superseeded Folder

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Waterjet		DL 18/07/24
100	Waterjet	2 pcs	8/3/18	8/3/18	0.00	0.95	Waterjet1		DL 18/07/24
110	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC2 Waterjet-4		DL 18/07/24
120	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC8-6		DL 18.07.25
130	Brake NC	2 pcs	8/3/18	8/3/18	0.00	1.06	Brake NC 1		DAS 38
140	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC5		9-89
150	Autoweld 1	2 pcs	8/3/18	8/3/18	0.00	1.76	Automated welding		EL
160	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC10		EL
170	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC5		EL
180	HandFinish	2 pcs	8/3/18	8/3/18	0.00	0.67	HandFinish4		SLD 18-07-26
190	QC	2 pcs	8/3/18	8/3/18	0.00	0.00	QC3		DL 18-7-27
200	Packaging	2 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-2		DAS
210	QC21-SA	2 Ea	8/3/18	8/3/18	0.00	0.00	QC21		53 JUL 30 2018

Part Op 100 - 1-Cut as per Dwg (D5489-7) Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 150 - ***SEE NOTE 9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH:
180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 138886 Exp 7/19
200 - LOCATION : FP002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.3200 sf (.16 ea)	90-Start up Operation	SOS0376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	124	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ Misaligned/off center ☐
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 1270 Aberdeen Street
 Hamlet, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S095765
 Part: D5489 - 047
 Job No: 181190
 Serial No/Batch: S095765
 Revision: A
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 07/24/18

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

QQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

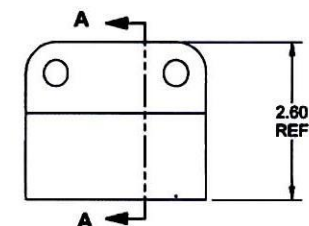
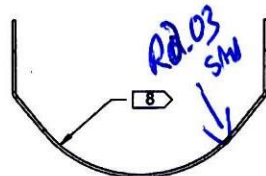


QA Closed: _____ Date: _____

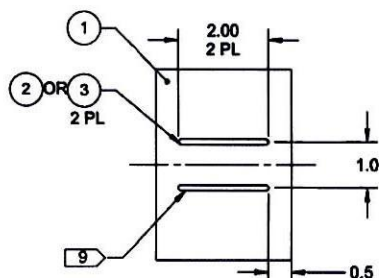
Work Order update only ☐

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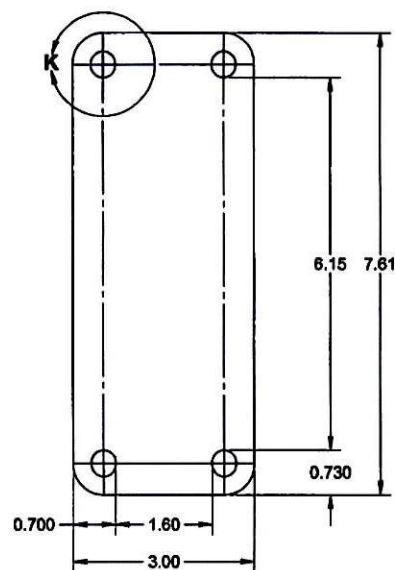
ITEM	QTY -047	P/N	DESCRIPTION
	X	D5489-047	WEARPLATE ASSEMBLY
1	1	D5489-7	WEARPLATE
2	A/R	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	A/R	2059B	HARDCOAT SURFACING MANUAL WELDING



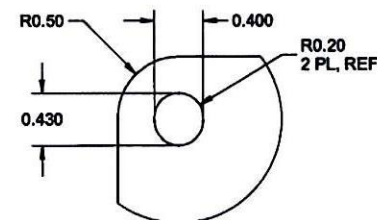
D5489-7 WEARPLATE
(MAKE FROM D5489-7F)



D5489-047 WEARPLATE ASSEMBLY



D5489-7F WEARPLATE
(FLAT PATTERN)



DETAIL K

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5059 OR AMS 5513 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.3 lbs
- 8) COAT ENTIRE TOP CONCAVE SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9
- 9) WELDING: BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

UNDER REVIEW

URF 18-736 NO

RELEASED
2017-10-31

APPROVED

DESIGN	SAD	DART AEROSPACE LTD	
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5489	SHEET 6 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	17.08.10	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
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